

IN THE CLAIMS

1. (Original) Double walled metal tube comprising a tubular roll formed metal band having a brazing layer between the metal layers of the tubular roll formed metal band, wherein the brazing layer consists of a copper alloy, the copper alloy being a copper-tin alloy, wherein the copper-tin alloy comprises 3-12 wt% tin.

2. (Original) Double walled metal tube according to claim 1, wherein the copper-tin alloy comprises 6-8 wt% tin.

3. (Currently Amended) Double walled metal tube according to claim 1 ~~or 2~~, wherein the copper- tin alloy comprises ~~essentially~~ about 7 wt% tin.

4. (Currently Amended) Double walled metal tube according to ~~any one of the preceding claims~~ claim 1, wherein the metal band is made of steel.

5. (Currently Amended) Double walled metal tube according to claim ~~[[4]]~~ 1, wherein the steel band is made of mild steel, ~~the mild steel preferably having a composition of 0.03-0.07 % C, \leq 0.02 % P, \leq 0.015 % S, \leq 0.06 % Si, 0.05-0.4% Mn, 0.02-0.07 % Al (all percentage in weight), the remainder Fe and unavoidable impurities. [[.]]~~

6. (Currently Amended) Double walled metal tube according to ~~any one of the preceding claims~~ claim 1, wherein the metal band from which the tube has been roll formed has a coating of a nickel layer on one side.

7. (Currently Amended) Metal band, ~~for instance~~ for producing double walled metal tubes according to ~~any one of claims 1-6~~ claim 1, the metal band having a width of essentially 20-80 mm, wherein a coating layer is present on at least one side of the metal band for brazing

the metal band, the coating layer being a copper-tin alloy, wherein the copper-tin alloy comprises 3-12 wt% tin.

8. (Currently amended) Metal band according to claim 7, wherein the copper-tin alloy comprises 6-8 wt% tin, ~~preferably essentially 7 wt% tin.~~

9. (Currently Amended) Metal band according to claim 7 ~~or 8~~, wherein the copper-tin alloy layer is present on both sides of the metal band, ~~the copper-tin alloy layer preferably having a thickness of 0.5-5 μ m on each side, more preferably 3-5 μ m on one side and 0.5-1.5 μ m on the other side, and still more preferably about 4 μ m on one side and about 1 μ m on the other side.~~

10. (Currently Amended) Metal band according to claim 7 ~~or 8~~, wherein the metal band has a coating of a nickel layer on one side of the metal band, ~~preferably a nickel layer having a thickness of 0.5-2 μ m on one side of the metal band and a copper-tin alloy layer having a thickness of 3-5 μ m on the other side of the metal band.~~

11. (Currently Amended) Metal band according to ~~any one of claims 7-10~~ claim 7, wherein the metal band consists of steel, ~~preferably mild steel, the mild steel preferably having a composition of 0.03-0.07 % C, \leq 0.02 % P, \leq 0.015 % S, \leq 0.06 % Si, 0.05-0.4 % Mn, 0.02-0.07 % Al (all percentage in weight), the remainder Fe and unavoidable impurities.~~

12. (Currently Amended) Metal strip, ~~for instance for making metal bands for producing double walled metal tubes according to any one of claims 1-6~~ claim 1, wherein a coating layer for brazing purposes is present on at-least one side of the metal strip, the coating layer being a copper-tin alloy, wherein the copper-tin alloy comprises 3-12 wt% tin.

13. (Currently Amended) Metal strip according to claim 12, wherein the copper-tin alloy comprises 6-8 wt% tin, ~~preferably essentially 7 wt% tin.~~

14. (Currently Amended) Metal strip according to claim 12 ~~or 13~~, wherein the copper-tin alloy layer is present on both sides of the metal strip, ~~the copper-tin alloy layer preferably having a thickness of 0.5-5 μ m on each side, more preferably 3-5 μ m on one side and 0.5-1.5 μ m on the other side, and still more preferably about 4 μ m on one side and about 1 μ m on the other side.~~

15. (Currently Amended) Metal strip according to claim 12, ~~13 or 14~~, wherein the metal strip has a coating of a nickel layer on one side of the metal strip, ~~preferably a nickel layer having a thickness of 0.5-2 μ m on one side of the metal strip and a copper-tin alloy layer having a thickness of 3-5 μ m on the other side of the metal strip.~~

16. (Currently Amended) Metal strip according to ~~any one of claims 12-15~~ claim 12, wherein the metal strip consists of steel, ~~preferably mild steel, the mild steel preferably having a composition of 0.03-0.07 % C, \leq 0.02 % P, \leq 0.015 % S, \leq 0.06 % Si, 0.05-0.4 % Mn, 0.02-0.07 % Al (all percentage in weight), the remainder Fe and unavoidable impurities.~~

17. (Original) Method of coating a metal strip with a coating layer consisting of a copper-tin alloy comprising the following steps:

- cleaning the metal strip;
- activating the surface of the metal strip;
- continuously coating at least one side of the metal strip with a copper-tin alloy layer comprising 3-12 wt% tin;
- posttreating the metal strip ~~(e. g. applying an anti-oxidising agent).~~

18. (Currently Amended) Method according to claim 17, wherein the metal strip is coated with a copper-tin alloy layer comprising 6-8 wt% tin, ~~preferably essentially 7 wt% tin.~~

19. (Currently Amended) Method according to claim 17 ~~or 18~~, ~~herein~~ wherein the metal strip is continuously coated with a layer of nickel on one side of the metal strip, ~~preferably before the coating of the copper-tin alloy layer.~~

20. (Currently Amended) Method according to claim 17, ~~18 or 19~~, wherein the metal band is coated using Physical Vapour Deposition (PVD), comprising the following steps:

- cleaning the metal strip;
- drying the metal strip;
- activating the metal strip;
- continuously coating at least one side of the metal strip with a copper-tin alloy layer comprising 3-12 wt% tin;
- cooling of the coated strip;
- applying an anti-oxidising agent.

21. (Currently Amended) Method according to claim 17, ~~18 or 19~~, wherein the metal band is coated using electroplating, ~~preferably using a copper plated layer and a tin plated layer, the coated metal being subsequently annealed to produce a copper tin alloy.~~

22. (Currently Amended) Method according to claim 17, ~~18 or 19~~, wherein the metal band is coated with a copper-tin alloy layer in a tin ion and copper ion containing cyanide bath.

23. (New) Double walled metal tube according to claim 1, wherein the steel band is made of mild steel having a composition of 0.03-0.07 % C, ≤ 0.02 % P, ≤ 0.015 % S, ≤ 0.06 %

Si, 0.05-0.4% Mn, 0.02-0.07 % Al (all percentage in weight), the remainder Fe and unavoidable impurities.

24. (New) Metal band according to claim 7, wherein the copper-tin alloy comprises about 7 wt% tin.

25. (New) Metal band according to claim 7, wherein the copper-tin alloy layer is present on both sides of the metal band, the copper-tin alloy layer having a thickness of 0.5-5 μm on each side

26. (New) Metal band according to claim 7, wherein the copper-tin alloy layer is present on both sides of the metal band, the copper-tin alloy layer having a thickness of 3-5 μm on one side and 0.5-1.5 μm on the other side

27. (New) Metal band according to claim 7, wherein the copper-tin alloy layer is present on both sides of the metal band, the copper-tin alloy layer having a thickness of about 4 μm on one side and about 1 μm on the other side.

28. (New) Metal band according to claim 7, wherein the metal band has a coating of a nickel layer on one side of the metal band having a thickness of 0.5-2 μm on one side of the metal band and a copper-tin alloy layer having a thickness of 3-5 μm on the other side of the metal band.

29. (New) Metal band according to claim 7, wherein the metal band consists of mild steel.

30. (New) Metal band according to claim 7, wherein the metal band consists of mild steel having a composition of 0.03-0.07 % C, ≤ 0.02 % P, ≤ 0.015 % S, ≤ 0.06 % Si, 0.05-0.4 % Mn, 0.02-0.07 % Al (all percentage in weight), the remainder Fe and unavoidable impurities.

31. (New) Metal strip according to claim 12, wherein the copper-tin alloy comprises about 7 wt% tin.

32. (New) Metal strip according to claim 12, wherein the copper-tin alloy layer is present on both sides of the metal strip, the copper-tin alloy layer having a thickness of 0.5-5 μm on each side.

33. (New) Metal strip according to claim 12, wherein the copper-tin alloy layer is present on both sides of the metal strip, the copper-tin alloy layer having a thickness of on one side and 0.5-1.5 μm on the other side

34. (New) Metal strip according to claim 12, wherein the copper-tin alloy layer is present on both sides of the metal strip, the copper-tin alloy layer having a thickness of about 4 μm on one side and about 1 μm on the other side.

35. (New) Metal strip according to claim 12, wherein the metal strip has a coating of a nickel layer on one side of the metal strip, the nickel layer having a thickness of 0.5-2 μm on one side of the metal strip and a copper-tin alloy layer having a thickness of 3-5 μm on the other side of the metal strip.

36. (New) Metal strip according to claim 12, wherein the metal strip consists of mild steel.

37. (New) Metal strip according to claim 12, wherein the metal strip consists of mild steel having a composition of 0.03-0.07 % C, ≤ 0.02 % P, ≤ 0.015 % S, ≤ 0.06 % Si, 0.05-0.4 % Mn, 0.02-0.07 % Al (all percentage in weight), the remainder Fe and unavoidable impurities.

38. (New) Method of coating a metal strip with a coating layer consisting of a copper-tin alloy comprising the following steps:

- cleaning the metal strip;
- activating the surface of the metal strip;
- continuously coating at least one side of the metal strip with a copper-tin alloy layer comprising 3-12 wt% tin;
- posttreating the metal strip comprising applying an anti-oxidising agent.

39. (New) Method according to claim 17, wherein the metal strip is coated with a copper-tin alloy layer comprising about 7 wt% tin.

40. (New) Method according to claim 17, wherein the metal strip is continuously coated with a layer of nickel on one side of the metal strip before the coating of the copper-tin alloy layer.

41. (New) Method according to claim 17, wherein the metal band is coated using electroplating, using a copper plated layer and a tin plated layer, the coated metal being subsequently annealed to produce a copper-tin alloy.